

Work Order ID 85373

85373

Page 1

June-07-12 9:18:51 AM

Item ID: D412-694-017

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearing Overhaul

Stop ***NS2***

Start Date: 07/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 21/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/07 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-694-017

CHG001

Silber
JB

ML5 12-6-27

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/06/26 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Silber

EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85373

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Item ID: D412-694-017

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearing Overhaul

Stop ***NS2***

Start Date: 07/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 21/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-694-017 Location: 121 PPP Rev: _____

12/6/28

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/29

ME
12-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Printt

June-07-12 9:18:54 AM

Page 1

Work Order ID: 85373

85373

Parent Item: D412-694-017

D412-694-017

Parent Item Name: Bearing Overhaul

Start Date: 07/06/2012

Required Date: 21/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-04-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-21

Manufactured

No

120

Each

16.0000

7

7

✓

**

85332 JB

SP

D3121-21

Bolt

Location

Loc Qty

Loc Code

ST235

16

66969

1

79732

4

83364

11

D3121-241

Manufactured

No

120

Each

54.0000

5

5

✓

**

JB

SP

D3121-241

Bearing Assembly

Location

Loc Qty

Loc Code

ST235A

54

67280

3

85298

51

D3137-3

Manufactured

No

120

Each

26.0000

1

1

✓

**

85298

JB

12/06/26

D3137-3

Guide

Location

Loc Qty

Loc Code

ST235A

26

76873

1

79735

25

79735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85373

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Parent Item: D412-694-017

D412-694-017

Parent Item Name: Bearing Overhaul

Start Date: 07/06/2012

Required Date: 21/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3137-5

Manufactured No

120

Each

6.0000

D3137-5

Washer

**

85688 JB

Location

Loc Qty

Loc Code

ST235A

6

46740

3

77022

3

D3183-045

Manufactured No

120

Each

34.0000

D3183-045

Bearing Assembly

**

JB

Location

Loc Qty

Loc Code

ST236

34

77830

1

79697

4

80903

29

MS24694-S101

Purchased No

120

Each

33.0000

MS24694-S101

Screw

**

JB 12/06/26

Location

Loc Qty

Loc Code

ST290A

33

120498

13

121443

10

121708

10

120498

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X			1					D412-694-011	SPACEDOOR™ INSTALLATION
	X		1					D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X	1					D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
1			1	X				D412-694-01	DOOR ASSEMBLY
1			1		X			D412-694-02	DOOR ASSEMBLY
1			1			X		D412-694-03	DOOR ASSEMBLY
1			1				X	D412-694-04	DOOR ASSEMBLY
2			1					D2126-0730	SEAL
4			1					D3090-1	SHIM
4			1					D3090-3	SHIM
2			1					D3108-1	DECAL
2			1					D3108-2	DECAL
4			1					D3108-3	DECAL
4			1					D3108-5	DECAL
2			1					D3108-7	DECAL
			1			1	1	D3110-1	ESCUTCHEON
			1			1	1	D3110-3	HANDLE
			1	1	1			D3110-5	HANDLE ASSEMBLY
			1			1	1	D3111-041	PLATE ASSEMBLY
			1			2	2	D3112-1	GUIDE
			1			1	1	D3113-1	SPRING
			1			1	1	D3114-1	PIVOT
			1	1				D3115-1	BRACKET
2			1					D3116-1-0500	SEAL
			1			1	1	D3116-11-0180	SEAL
2			1					D3116-3-0500	SEAL
			1			1	1	D3116-5-0680	SEAL
			1	1	1			D3116-7-0680	SEAL
			1	1	1			D3116-9-0770	SEAL
		1	1					D3117-1-0980	SEAL RETAINER
		1	1					D3117-3-0980	SEAL FILLER
4			1					D3118-3	SIGN ASSEMBLY
4			1					D3118-5	SIGN ASSEMBLY
			1			1		D3119-041	COVER ASSEMBLY
			1				1	D3119-042	COVER ASSEMBLY
			1			1		D3120-1	COVER
			1				1	D3120-2	COVER
			1			1		D3120-3	COVER
			1				1	D3120-4	COVER
			1	3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
			1	1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
			1		1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			1					D3121-21	SCREW

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Revision: B

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			5					D3121-241	BEARING ASSEMBLY
			1	1				D3122-1	LEVER
			2	2				D3123-1	CAM
			1	1				D3124-1	HOOK
			1	1				D3124-2	HOOK
						1	1	D3125-1	LEVER
						1	1	D3125-3	LEVER
						1	1	D3125-5	LEVER
						1	1	D3125-7	LEVER
			1	1				D3126-1	BRACKET ("SLIDER")
			1	1				D3126-3	BRACKET ("SLIDER")
			5	5				D3126-5	BRACKET ("SLIDER")
			1	1				D3127-1	SPACER
						1	1	D3128-1	SHIM
						2	2	D3129-1	LEVER
						2	2	D3130-1	CLEVIS BASE
						1	1	D3131-1	STOP
			1					D3132-041	ROD WELDMENT
					1			D3132-042	ROD WELDMENT
					1			D3133-041	ROD WELDMENT
			1					D3133-042	ROD WELDMENT
						1	1	D3134-1	ROD
						1	1	D3134-3	ROD
			1	1				D3135-041	HANDLE WELDMENT
								D3136-041	WINDOW ASSEMBLY
			2					D3137-041	BRACKET ASSEMBLY ("ROLLER")
			1					D3137-3	GUIDE
			1					D3137-5	WASHER
			1					D3138-1	COVER
					1			D3138-2	COVER
			1	1				D3139-1	GUARD
			1					D3139-3	GUARD
					1			D3139-4	GUARD
			1					D3140-05	DOOR
					1			D3140-06	DOOR
						1		D3140-07	DOOR
							1	D3140-08	DOOR
			2	2				D3141-1	SPRING
						1	1	D3143-1	CLEVIS
						3	3	D3143-3	CLEVIS
						1		D3144-1	DOUBLER
						1		D3144-105	DOUBLER
						1		D3144-107	DOUBLER
			1					D3144-109	DOUBLER
			1	1				D3144-111	DOUBLER
					1			D3144-115	DOUBLER
							1	D3144-117	DOUBLER
							1	D3144-119	DOUBLER

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
					1		1	D3144-121	DOUBLER
					1			D3144-123	DOUBLER
				1	1			D3144-13	DOUBLER
				1				D3144-3	DOUBLER
						1		D3145-1	HINGE BRACKET
							1	D3145-2	HINGE BRACKET
						1		D3146-1	HINGE BRACKET
							1	D3146-2	HINGE BRACKET
						2	2	D3147-1	PIN
				2	2			D3148-1	CLEVIS
						2	2	D3149-1	STRIKER PLATE
						2	2	D3150-1	GUIDE
				1	1			D3151-041	DOUBLER ASSEMBLY
				1				D3152-041	BRACKET ASSEMBLY
					1			D3152-042	BRACKET ASSEMBLY
	1							D3153-11	PANEL
	1							D3153-12	PANEL
	1							D3153-13	PANEL
	1							D3153-14	PANEL
	1							D3153-15	PANEL
	1							D3153-16	PANEL
						1	1	D3154-1	KEY
				1	1			D3155-041	BRACKET ASSEMBLY
				1	1			D3155-042	BRACKET ASSEMBLY
				2	2			D3156-1	BRACKET
						2	2	D3157-1	SPACER
						3	3	D3159-041	BRACKET ASSEMBLY
						1		D3159-043	BRACKET ASSEMBLY
							1	D3159-044	BRACKET ASSEMBLY
				12	12			D3162-041	BRACKET ASSEMBLY
				1				D3163-041	COVER ASSEMBLY
					1			D3163-042	COVER ASSEMBLY
				1				D3183-041	BRACKET ASSEMBLY ("ROLLER")
					1			D3183-042	BRACKET ASSEMBLY ("ROLLER")
			2					D3183-045	BEARING ASSEMBLY
				1	1			D3203-1	HANDLE ASSEMBLY
2								D3300-1	WINDOW
				2	2			D3308-1	DOUBLER
				55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
	60							A6K75	RIVNUT
				10	10			AN525-10R6	SCREW
				8	8	4	4	AN525-10R7	SCREW
						8	8	AN960JD10	WASHER
				18	18	4	4	AN960JD10L	WASHER
				13	13	32	32	AN960JD10LL	WASHER
				6	6			AN960JD416L	WASHER
						4	4	AN960JD6L	WASHER
				6	6			AN960JD8	WASHER
						2	2	AN960JD8L	WASHER

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Revision: **B**

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			1			2	2	AN960JD8LL	WASHER
			1			10	10	ASL4-632-80	INSERT
			1	87	87	47	47	BSP45	RIVET
			1			14	14	FW10-032	WASHER
			1			6	6	FW4-032	WASHER
			1	12	12			M7885/2-4	RIVET (OR CR3213-4-3)
			1			3	3	M7885/3-4	RIVET (OR CR3212-4-3)
			1			2	2	MS20392-1C11	PIN
			1			5	5	MS20392-2C15	PIN
			1	2	2			MS20392-2C17	PIN
			1	2	2	2	2	MS20392-2C9	PIN
			1	2	2			MS20392-3C21	PIN
			1	8	8			MS20426AD3	RIVET
			1	20	20			MS20426AD4	RIVET
			1	A/R	A/R			MS20995-C20	LOCKWIRE
			1			6	6	MS21042L06	NUT
			1	6	6	2	2	MS21042L08	NUT
			1			5	5	MS21042L3	NUT
			1	4	4			MS21042L4	NUT
			1	4	4			MS21072-L3	NUTPLATE
			1	6	6	9	9	MS24665-151	COTTER PIN
				4	4			MS24693-S271	SCREW
						2	2	MS24694-C4	SCREW
				4	4			MS24694-C5	SCREW
			1					MS24694-S101	SCREW
				6	6			MS24694-S5	SCREW
				18	18			MS24694-S50	SCREW
						4	4	MS24694-S56	SCREW
						2	2	MS24694-S6	SCREW
						4	4	MS24694-S60	SCREW
				4	4			MS24694-S98	SCREW
						2	2	MS25281-R6	CLAMP
				2	2	2	2	MS27039-1-05	SCREW
				14	14	12	12	MS27039-1-06	SCREW
				13	13	6	6	MS27039-1-08	SCREW
						2	2	MS35206-231	SCREW
				2	2			MS35275-233	SCREW
				2	2			MS35649-264	NUT
						4	4	MS35650-305T	NUT
				2	2			MS35650-3252	NUT
				2	2	3	3	MS51859-7	WASHER
						4	4	NAS1169-10L	WASHER
						1	1	NAS388-6-12P	SCREW
	60					14	14	NAS388-6-8P	SCREW
	60					15	15	NAS391B6P	WASHER
				7	7			NAS43DD3-10	SPACER
				6	6			NAS43DD3-14	SPACER
						2	2	NAS43DD3-40	SPACER

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